

Date: Wednesday, 5/31/2006 7:39:45 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STA 155 BRACKET		
Job Number	: 27303		Part Number	: D28042		
Estimate Number	: 11040		Drawing Number	: D2804 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 5/31/2006 S.O. No. : N/A		Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A Type : SMALL /MED FAB		Due Date	: 6/18/2006 Qty: 10 Um: Each		
Previous Run	: 27142					
Written By	: <i>See comment below</i>					
Checked & Approved By	: <i>KJ 06.05.31</i>					
Comment	: Est. A0011.06 New Issue EC Est. B06.05.30 Blanks on wtjetEC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X12000	6061-T6 Bar .50" x 12.0"   <b>Comment:</b> Qty.: 0.7875 f(s)/Unit Total : 7.8750 f(s) 6061-T6 Bar .50" x 12.0" Material: 6061-T6 bar 12.00" x 0.50" Batch: <i>M100046</i> <i>M 06 01 (10)</i>
2.0	WATER JET	FLOW WATER JET   <b>Comment:</b> FLOW WATER JET 1-Cut as per Template DT8534 Dwg Rev: <i>B</i> Prog Rev: <i>B</i>  2-Deburr if necessary <i>M 06 01 (10)</i>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1   <b>Comment:</b> HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA103 <i>gnl 06/06/10 10</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE   <b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <i>M 06/06/10 16</i>
5.0	QC8	SECOND CHECK   <b>Comment:</b> SECOND CHECK <i>JL 06/06/11 (10)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

DQA: 

Date: 06/06/13

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

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Drawing Name: STA 155 BRACKET

Job Number: 27303

Part Number: D28042

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr

*ml 06/06/10*

10

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*JL 06/06/11*

⑥

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*SAD 06/06/11*

10

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST156

*106/12/6 ⑩*

1

10.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*106/06/13 ⑩*

Job Completion



*6/06/13*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD	Work Order:	27303
Description: STA 155 Bracket	Part Number:	D2804-2
Inspection Dwg: D2804	Rev: B	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>qml</u>	Audited by:	<u>Ep</u>	Prototype Approval:	N/A
Date:	06/06/10	Date:	06/06/10	Date:	N/A

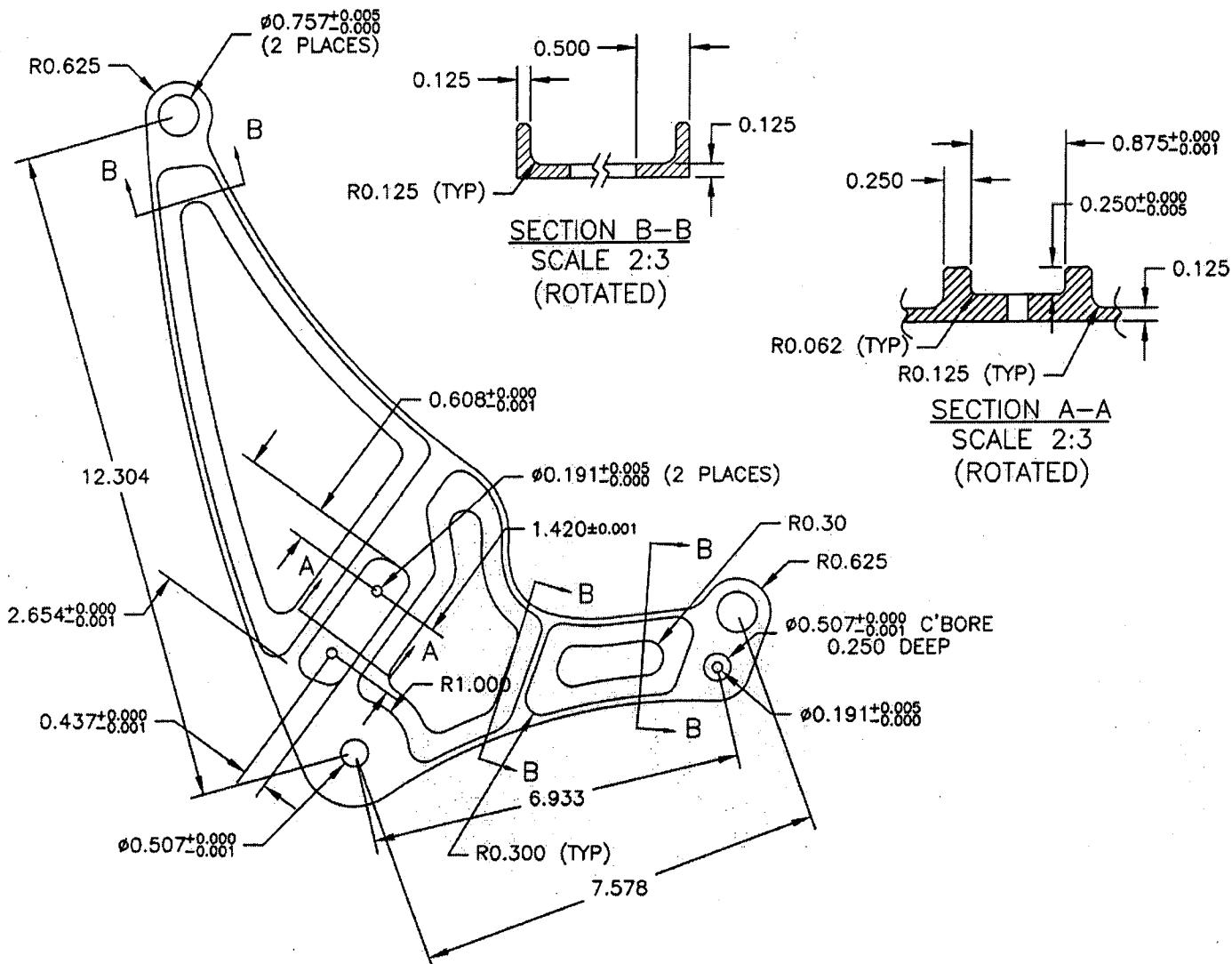
Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	
B	05.04.25	Added 0.500 dimension	KJ/JLM	



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>✓</i>	APPROVED <i>✓</i>	DRAWING NO. D2804	REV. B SHEET 1 OF 2	
DATE 04.11.22		TITLE STA 155. BRACKET	SCALE 1:3	
A	00.11.07	NEW ISSUE		
B	04.11.22	ADD CUTOUTS & -043/-044		

RELEASED

05.03.11 ~~11~~



D2804-1 BRACKET (SHOWN), D2804-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2804.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 T
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

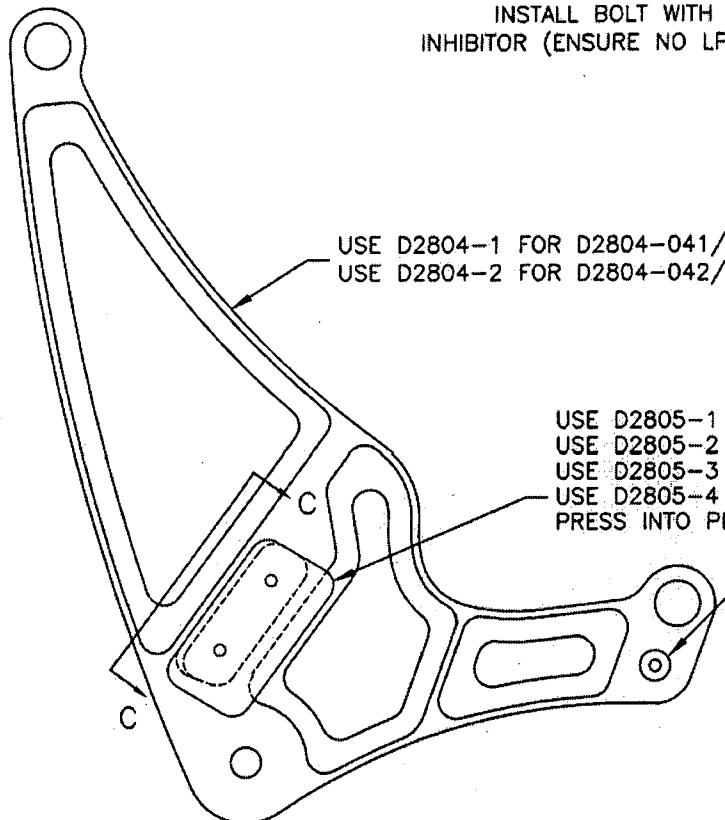
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THICK  
WORK ORDER  
NO. 27303

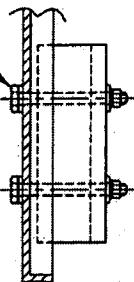
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**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>11</i>	APPROVED <i>11</i>	DRAWING NO. D2804	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 155 BRACKET	SCALE 1:3



AN3C16A BOLT (1)  
NAS1515H3 WASHER (2)  
MS21043-3 NUT (1)  
INSTALL BOLT WITH LPS-3 CORROSION  
INHIBITOR (ENSURE NO LPS-3 ON THREADS)  
(2 PLACES)



SECTION C-C  
SCALE 1:3  
(ROTATED)

USE D2805-1 FOR D2804-041  
USE D2805-2 FOR D2804-042  
USE D2805-3 FOR D2804-043  
USE D2805-4 FOR D2804-044  
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE PRIOR TO  
POWDER COAT

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WORK ORDER  
NO. *27303*

D2804-041/-043 BRACKET ASS'Y (SHOWN)  
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6)  
OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3

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